

Date: Wednesday, 08/04/2009 10:49:34 AM
 User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	AFT BLADE FOLD ASSEMBLY
Job Number :	47089		
Estimate Number :	13532		
P.O. Number :		Part Number :	PB674300103
This Issue :	08/04/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	B6743001 P.1,3,4,15
First Issue :	//	Project Number :	N/A
Previous Run :	45649	Drawing Revision :	B1
	Type :	Material :	
	SMALL /MED FAB	Due Date :	29/04/2009
Written By :		Qty:	1 Um: Each
Checked & Approved By :	<i>MF 09-04-08.</i>		
Comment	Est Rev:A 08-07-30 new issue DD verified by:ec Est Rev:B 08-12-04 up date part list DD Verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB674300109	Aft Blade Fold Assembly Weldment
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Aft Blade Fold Assembly Weldment
 batch: *347087*

MF 09-04-28

2.0	PB674300113	Aft Adjustable Blade Support Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Aft Adjustable Blade Support Assembly
 batch: *347051*

MF 09-04-28

3.0	PB674300117	Aft Adjustable Blade Support Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Aft Adjustable Blade Support Assembly
 batch: *347053*

MF 09-04-28

4.0	PB674300121	PB67-43001-21
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 PB67-43001-21
 batch: *347054*

MF 09-04-28

5.0	PB674300123	PB67-43001-23
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 PB67-43001-23
 batch: *347055*

MF 09-04-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 47089

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PB674300137

PB67-43001-37



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

PB67-43001-37

batch: 345029

MF 09-04-28

7.0

PB674300157

Stabilizer Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Stabilizer Arm

batch: 347059

MF 09-04-28

8.0

PB674300159

PB67-43001-59



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

PB67-43001-59

batch: 47060

MF 09-04-28

9.0

PB674300163

Handle Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle Assembly

batch: 47061

MF 09-04-28

10.0

PB6743001135

Male Eye



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Male Eye

batch: 45000

MF 09-04-28

11.0

PB6743001155

Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pin

batch: 43092

MF 09-04-28

12.0

PB6743001261

Lever Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Lever Arm

batch: 47094

MF 09-04-28

W/O:		WORK ORDER CHANGES					
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Job Number: 47089

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PB6743001265

Bushing



Comment: Qty.: ~~5~~ 4.0000 Each(s)/Unit Total : ~~4~~ 4.0000 Each(s)

Bushing

batch: 46932

MF 09-04-28

14.0

PB6743001299

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bushing

batch: 44969

MF 09-04-28

15.0

PB6743001305

Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bearing

batch: 47044

MF 09-04-28

16.0

D3451045

Handle and Lock-Down Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle and Lock-Down Assembly

batch: 47036

MF 09-04-28

17.0

MS518598

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

batch: m108987

MF 09-04-28

18.0

MS21042L5

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Nut

batch: m109840

MF 09-04-28

19.0

AN526A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BOLT

batch: m18057

MF 09-04-28

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Job Number: 47089

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

NAS1149F0532P

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

BATCH: m18057

MF 09-04-28

21.0

D3451043

Handle and Lock-Down Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle and Lock-Down Assembly

batch: 47046

MF 09-04-28

22.0

D34401

Tube Guide (Supersedes B67-43001-25/-307)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Tube Guide

batch: 41347

MF 09-04-28

23.0

D34403

Clamp (Supersedes B67-43001-309)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Clamp

batch: 41348

MF 09-04-28

24.0

D34441

Velcro Loop Belt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Velcro Loop Belt

batch: 41457

MF 09-04-28

25.0

D34491

Pad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pad

batch: 45257

MF 09-04-28

26.0

D34479

Swing Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Swing Arm

batch: 46263

MF 09-04-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 47089

Part Number: PB674300103

Job Number:



Seq. #:	Machine Or Operation:	Description :
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27.0	086004	Inventory
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Inventory
batch: m109350

MF 09-04-28

28.0	MS27039107	Screw
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Screw
batch: m18106

MF 09-04-28

29.0	MS27039123	SCREW
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
SCREW
batch: m18057

MF 09-04-28

30.0	MS21042L4	Nut
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Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)
Nut
batch: m110450

MF 09-04-28

31.0	MS21042L6	Nut
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Nut
batch: m110002

MF 09-04-28

32.0	MS518596	WASHER
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
WASHER
batch: m108986

MF 09-04-28

33.0	MS518598	WASHER
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
WASHER
batch: m108987

MF 09-04-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 47089

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

NAS43DD368

SPACER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SPACER

batch: m110983

MF 09-04-28

35.0

NAS1149F0316P

WASHER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WASHER

batch: m11117

MF 09-04-28

36.0

NAS1149F0432P

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Washer

batch: m18057

MF 09-04-28

37.0

NAS1149F0632P

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

batch: m18057

MF 09-04-28

38.0

NAS1149F0832P

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

batch: m18057

MF 09-04-28

39.0

AN960JD6

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Washer

batch: 6085

MF 09-04-28

40.0

AN410A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: m108986

MF 09-04-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

AN413A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

batch: m110731

MF 09-04-28

42.0

AN416A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch: _____

or AN415A (see engineering) batch: m110399

MF 09-04-28

43.0

AN611A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

BOLT

batch: m110155

MF 09-04-28

44.0

AN628A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: _____

or AN6016A (see engineering) batch: 111636

MF 09-04-28

45.0

AN813A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

BOLT

batch: m110915

MF 09-04-28

46.0

BSP43

RIVET



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

RIVET

batch: m1109119

MF 09-04-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 47089

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

47.0

CR3213405

cherry rivet



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

cherry rivet

batch: m108473

MF 09-04-28

48.0

MS17984C413

PIN, QUICK RELEASE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

PIN, QUICK RELEASE

batch: _____

or MS17984C410 (see engineering) batch: m18118

MF 09-04-28

49.0

MS17984C418

PIN, QUICK RELEASE



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

PIN, QUICK RELEASE

batch: m108991

MF 09-04-28

50.0

30345T21

LANYARD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

LANYARD

batch: m17828

MF 09-04-28

51.0

30345T24

LANYARDS



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

LANYARDS

batch: m108973

MF 09-04-28

52.0

240107

SPRING SLOTTED PIN



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

SPRING SLOTTED PIN

batch: m111088

MF 09-04-28

53.0

3408A98

DETENT BALL SPRING PLUNG



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DETENT BALL SPRING PLUNG

batch: m108390

MF 09-04-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

54.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per dwg and use 242 threadlock A/R shown on dwg PB67-43001 page 2.

242 THREADLOCK batch: *M109687*

PC 09.05.06 1

55.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

509/05/07 (X)

56.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPA 47586

PC 9/5/7 (U)

57.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/07

Job Completion



MF 09-05-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

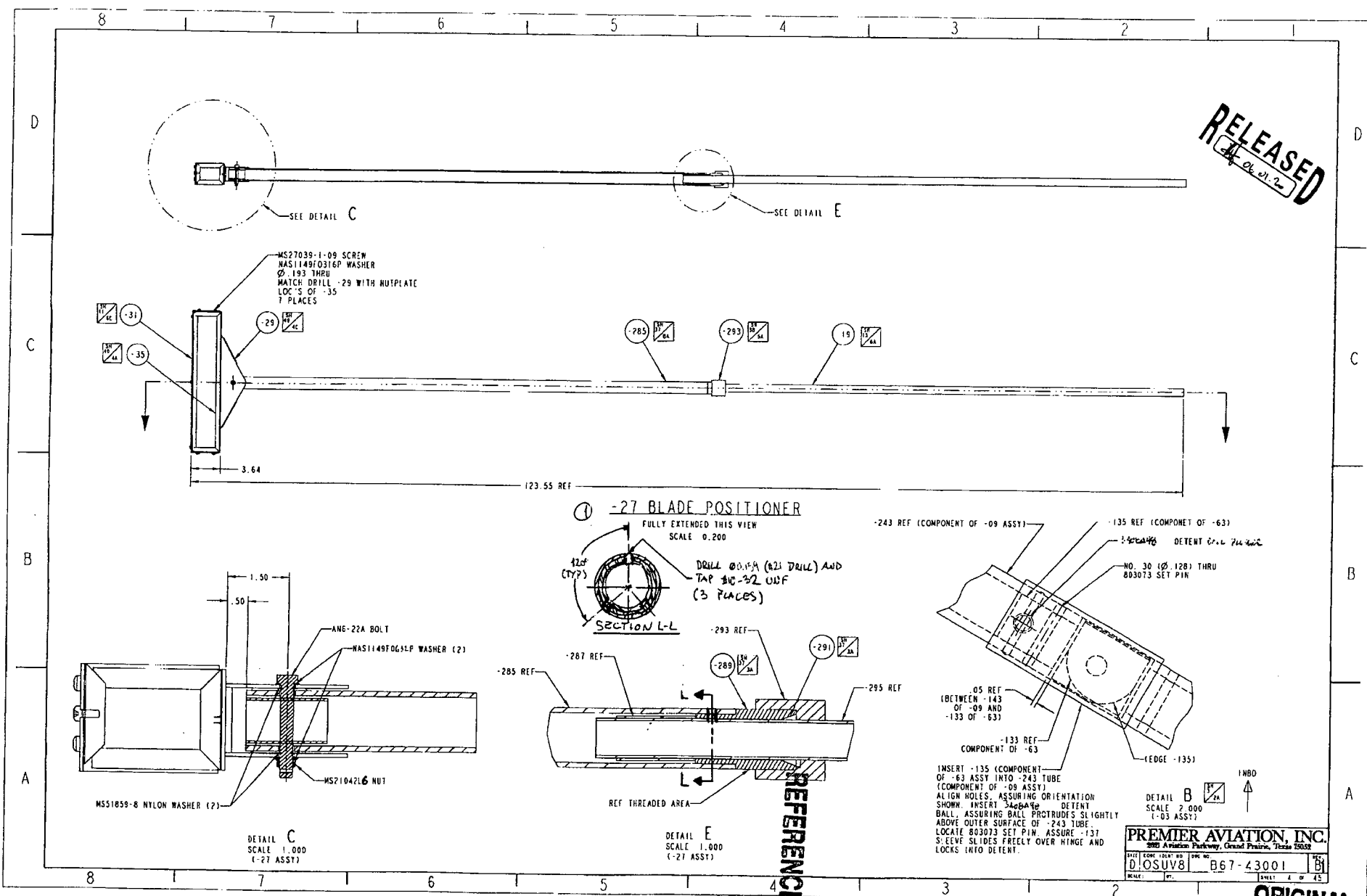
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

RELEASED
JUL 21 1967



REFERENCE ONLY

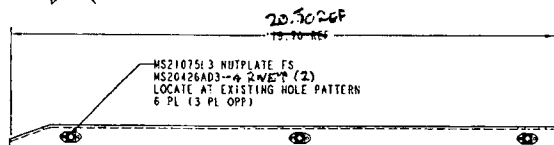
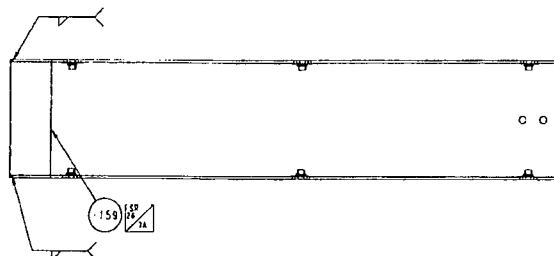
PREMIER AVIATION, INC.
3900 Aviation Parkway, Grand Prairie, Texas 75052

SIZE	COMP	IDENT NO	DOC NO
D	OSUV8	B67-43001	81
SHEET		A OF 45	

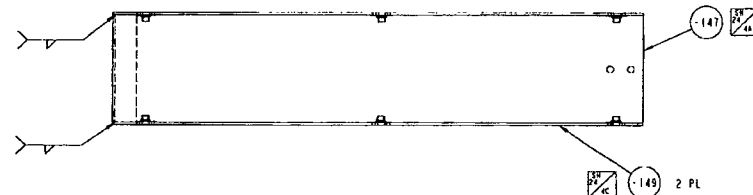
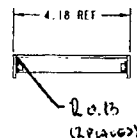
ORIGINAL

#47089

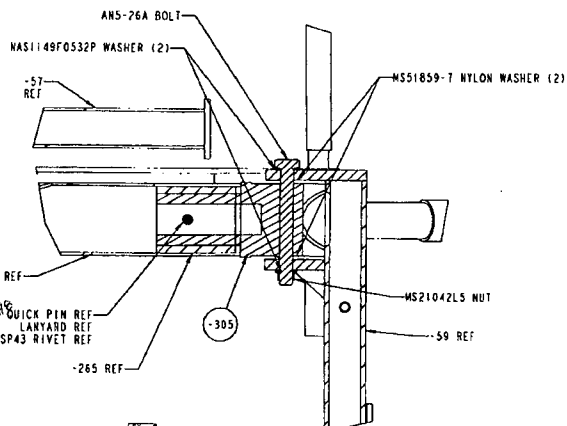
RELEASED
47089



② -71 20 DEGREE BLADE SUPPORT ASSEMBLY
SCALE 0.500



② -67 90 DEGREE BLADE SUPPORT ASSEMBLY
SCALE 0.500



DETAIL A
SCALE 0.750
(-03 ASSY)

MS21075L3 NUTPLATE FS
MS20426AD3-4 RIVET (2)
6 PL (3 PL OPP)

REFERENCE ONLY

PREMIER AVIATION, INC.
2800 Aviation Parkway, Grand Prairie, Texas 75048
DATE: 08-19-84
DRAWN BY: DLOSJV8
CHECKED BY: B67-43001
SCALE: 1" = 4.5"

ORIGINAL

#47089